

S263940



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246



**D5805-5**  
**Job Sheet 208156**



POSITIVE  
RECALL

Part No: D5805-5

Job Qty: 12 pcs

Part Name: Cap



Part Weight: 0 lbs

Status: New

Job Created: 3/12/20

Job Tracking No:

POSITIVE RECALL

EFFECTIVE 3/12/20 AUTH MDE

RELEASED DATE

Priority: Medium

Due Date: 3/24/20

Created By: Jennifer Renwick

Type: Stock

Description:

Note: URF 20-522 DWG D5805 REV.A IPP REV:A NEW ISSUE 20.01.15 JV VERF:DD

Ship Via:

### Bill of Materials

### Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
100	Waterjet - Flow - 1	12 pcs		3/24/20	0.17	0.60	Waterjet - Flow	20/03/13
							Waterjet - Omax	
110	QC 2	12 pcs		3/24/20	0.00	0.00	QC 2 - 1	20/03/13
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	

				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
120	QC 8	12 pcs	3/24/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
190	Packaging 3-1 - Stock - B4B	12 pcs	3/24/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B

DAS  
MAR 17 2020 40  
9-89

*MAC*



				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	DAS
140 QC 21 - SA	12 pcs	3/24/20	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	70
				QC 21 - SA - 53	53

Part Op 100 - 1-Cut as per DWG D5805-5. DWG. Rev: A PROG. Rev: A 2-Deburr if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Identify as per dwg & Stock Location: \_\_\_\_\_

140 - QC21- Final Inspection - Work Order Release

MAR 17 2020

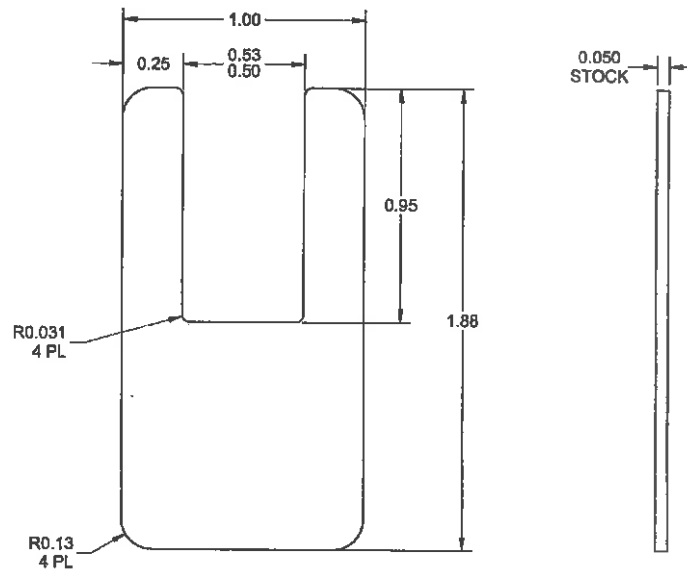
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M1010S18GA	1010/1025 Sheet .048	.1812 sf (.0151 ea)	100-Waterjet - Flow - 1	FM137041-1

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M1010S18GA	0	84	0

Part Specifications	
Specifications could not be found.	

Plex 3/12/20 9:18 AM Dart.lajeunesse.marie





**D5805-5 CAP**  
(DERIVED FROM AERO DESIGN P/N 76423-04)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 208156 ML5  
20-08-12

UNDER REVIEW  
URF 2020-522 20.02.14 (NO)

- NOTES:**
- 1) MATERIAL: AISI 1010/1025 STEEL SHEET, COLD ROLLED, #18 GA (0.050 THICK)  
PER ASTM A36/A368/A1008 OR CSA G40-21 36W/44W/50W/60W/70W  
REF DART SPEC M1010-S18GA
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.02 lbs

**RELEASED**  
2020 FEB 18 ND

APPROVED

DESIGN	ZF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D5805</b> TITLE <b>ATTACHMENT HOOP</b> <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS          NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT          THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	REV. A
DRAWN	ZF		SHEET 6 OF 6
CHECKED	KPT		SCALE
MFG. APPR.	DD		NTS
APPROVED	NO		
DE APPR.	CP <u>41</u>		
DATE	20.01.13		

# Purchase Order Receipt Listing

Page 1 of 2

Monday, March 13, 2017 8:40:22 AM

All amounts are calculated in domestic currency.

All Vendors PO ID PO35495 Receipt Dates from 3/10/2017 to 3/10/2017 All Line Item Types  
All Item ID/GL/WOs All Rec. Employees All Currencies  
Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
Vendor ID/Vendor Name VC-CAM002 Acier Onellette Inc.											
PO35495	1		M1010918GA	sf	3/10/2017	3/10/2017	32.0000	\$1.13	0.0000	0	\$36.14
CAD	No		1010/025 SHEET	sf	32.0000	PLOU01		\$36.14	0.0000	0	
			048								
			m137041								
	2		M2024T3S.040	sf	3/10/2017	3/10/2017	48.0000	\$4.03	0.0000	0	\$193.51
	No		2024-T3 .040 sheet	sf	48.0000	PLOU01		\$193.51	0.0000	0	
			m137041								
	3		M703R0.750	f	3/10/2017	3/10/2017	12.0000	\$3.26	0.0000	0	\$39.08
	No		703 Round Bar 0.750	f	12.0000	PLOU01		\$39.08	0.0000	0	
			m137041								
	4		M304S20GA	sf	3/10/2017	3/10/2017	64.0000	\$2.94	0.0000	0	\$188.36
	No		304/316 .040 Sheet	sf	64.0000	PLOU01		\$188.36	0.0000	0	
			m137041								
	5		M6061T6S.063	sf	3/10/2017	3/10/2017	64.0000	\$2.35	0.0000	0	\$150.22
	No		6061-T6 .063 Sheet	sf	64.0000	PLOU01		\$150.22	0.0000	0	
			m137041								
	6		M6061T6S.188	sf	3/10/2017	3/10/2017	32.0000	\$7.40	0.0000	0	\$236.76
	No		6061-T6 .188 Sheet	sf	32.0000	PLOU01		\$236.76	0.0000	0	
			m137041								
	7		M7075T73R1.000	f	3/10/2017	3/10/2017	12.0000	\$6.59	0.0000	0	\$79.07
	No		7075-T73 Rd Bar 1.00 f	f	12.0000	PLOU01		\$79.07	0.0000	0	
			m137041								
	8		71550-15	Each	3/10/2017	3/10/2017	1.0000	\$35.29	0.0000	0	\$35.29
	No		TUBE HSS 3 X 3 X		1.0000	PLOU01		\$35.29	0.0000	0	
			0.188" ( 8 FT)								
			m137041								
	9		71550-15	Each	3/10/2017	3/10/2017	1.0000	\$271.08	0.0000	0	\$271.08
	No		6061-T6 BAR 2-1/2"		1.0000	PLOU01		\$271.08	0.0000	0	
			X 6" (5 FT)								
			m137041								

**ACIER OUELLETTE INC.**

935, Boul. du Havre  
Salaberry de Valleyfield (Québec) J6S 5L1  
Tél.: 450-377-4248 Mtl: 514-336-4248 Ext.: 800-667-4248  
Fax: 450-377-5696 Mtl: 514-336-4246 Ext.: 866-456-4242

**Order - Sales****Copy**

C000018604

**Customer N°** CLI0001056  
**Date** 2017/03/06  
**Delivery date** 2017/03/10  
**Your order N°** 35495  
**Processed by** Josianne Bourdon  
**Salesman**  
**Carrier** OUELLETTE VALLEYFIELD  
**Credit Terme** NET 30  
**Page** 1

**Billed to**

DART AEROSPACE LTD  
1270, ABERDEEN ST.  
HAWKESBURY, Ontario, K6A 1K7

**Shipped to**

DART AEROSPACE LTD  
, Ontario,

Att.: CHANTAL LAVOIE Tél.: 613-632-5200

**Delivery Route** 5

Product Description	Weight	Qty	U/M	PCS NB			Internal Use Only				
				CMD	EXP	B/O	IN	I	S	C	OUT
1 CR SHEET 18G (4 X 8) FECR-18G48 3280 1 X 4' X 8' HEAT: 162A03655	64.00	32.00	PI2_\$CLB	1.00							
2 ALU SHEET .040 (18G) 2024-T3 4B (4 X 12) FEAL-0404122024B 3118 1 X 4' X 12' HEAT: 187B4388	27.02	48.00	PI2_\$CLB	1.00							
3 ROUND SS 304 303 (12R) RSS-34303-12 5760 1 X 12' R/L HEAT: W4B3	18.02	12.00	PI1_\$CLB	1.00							
4 SHEET SS 20G SS304-2B (4 X 8) FESS-20G483042B 3430 2 X 4' X 8' HEAT: 825678	100.48	64.00	PI2_\$CLB	2.00							

Next Page...

## MATERIAL RECEIPT INSPECTION FORM

MATERIAL: 1010SS-A  
DATE: 12/02/16

PO / BATCH NO.: P033445 / 13704

MATERIAL CERT REC'D: 1/25  
QUANTITY RECEIVED: 32  
QUANTITY INSPECTED: 32  
QUANTITY REJECTED: 0

THICKNESS ORDERED: 1048  
THICKNESS RECEIVED: 1046  
SHEET SIZE ORDERED: 48"  
SHEET SIZE RECEIVED: 48"

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y N	
CORRECT FINISH	Y N	
CORROSION	Y N	
CORRECT GRAIN DIRECTION	Y N	
CORRECT MATERIAL	Y N	CP 1010
CORRECT THICKNESS	Y N	1046
PHOTO REQUIRED	Y N	
CORRECT MATERIAL	Y N	AIN A102
CORRECT REF # TO LINK CERT	Y N	Head # 1010
CORRECT MATERIAL IDENTIFICATION	Y N	1010SS-A
CORRECT M# ON THE MATERIAL	Y N	113704
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y N	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK, RECORD RESULTS BELOW				
TYPE OF MATERIAL	HRC	HRB	DUR A	DUR D
SIZE OF TEST SAMPLE				
HARDNESS / DUROMETER READING				

*testers located in the Quality Office*

<b>QC &amp; INSPECTION</b> INSPECTED BY: <u>48</u> DATE: <u>12/02/16</u>	<b>ENGINEERING SIGNOFF (if required)</b> SIGNED OFF BY: _____ DATE: _____
--------------------------------------------------------------------------------	---------------------------------------------------------------------------------

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in





“首钢”牌产品质量证明书  
QUALITY CERTIFICATE OF “SHOUGANG” BRAND

营销中心地址: 中国北京市石景山区  
ADD. OF SHOWSANG GROUP: SHIJINGSHAN DISTRICT, BEIJING, CHINA  
邮政编码 POST CODE: 100041  
电话TEL: (+8610) 68281603  
或电邮地址E-MAIL: SG@MAIL.SHOWSANG.COM.CN  
营销中心地址: 中国河北省唐山市曹妃甸工业区 083200  
ADD. OF SALES/FACTORY: CAOFEDIAN INDUSTRY PARK, TANGSHAN,  
HEBEI, P.R. CHINA 063200

製造廠：中國鐵鋼聯合有限公司  
MANUFACTURER: SHOUHANG GROUP, SHOUHANG-INTANG UNITED IRON & STEEL CO., LTD.

订货单位 CUSTOMER		中国船舶工业工程公司				合同号 CONTRACT NO.		D000098750-000020/0001582400				许可证号 LICENSE NO.														
收货单位 PURCHASER		中远（舟山）船务有限公司				交货状态 CONDITION OF SUPPLY		通海				证明书的号 CERTIFICATE NO.		Z10008203780												
产品名称 PRODUCT		散装 Coal-Burning Ship				发货日期 DATE OF DELIVERY		2016-02-27 10:05:49				表号 RECORD NO.		SD-09-01A												
规格 SPECIFICATION		ASTM A106/A106M-12010				牌号 STEEL GRADE		CS Type B				页号 PAGE NO.		共1页，第1页												
炉批号 COIL NO.	炉次号 HEAT NO.	表面 S.G.	尺寸 Size (MM)		件数 PCS.	重量 WGT. TON	化学成分: CHEMICAL COMPOSITION %										性能 MECHANICAL PROPERTIES									
			厚度 THK.	宽度 WIDTH.			C	Si	Mn	P	S	Al	Ti	Nb	N	屈服强度 Y.S. N/mm <sup>2</sup>	抗拉强度 T.S. N/mm <sup>2</sup>	伸长率 Elong. %	断面收缩率 Redl. %	冲击功 KV2 J	夏比 Charpy J	BH N/mm <sup>2</sup>				
16B2204420020	162A03655	FB	1.12	1219	1	12.130	300	1	20	10	0.005	40	12	10	29	263		41.5								
16B22044200310	162A03659	FB	1.12	1219	1	12.300	300	1	20	10	0.005	40	12	10	29	263		41.5								
以下空白			None	Empty																						
合计 TOTAL					2	24.430																				
备注 REMARKS: 发车(船)号: 黄015655																										
1. 本产品已按上述要求逐件检验合格。其性能符合要求，特此声明。WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN IS USED AND TESTED WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE MATERIAL SPECIFICATION.																	审核 CHECK		质量检验和验收人 Person in Charge of Quality Inspection							
2. 本质量保证书中空白项目均不作为本产品的交付条件。THE BLANK ITEMS IN THIS GUARANTEE BE REGARDED AS DELIVERY CONDITIONS.																										
3. 质量保证书的质量证明书将随货物一起发出，并带有有效的印章。 The quality certificate will come into force with a valid stamp.																	质检		褚志勤							
日期 Date: 2016-03-27																										

C 650 306  
C 650 315

Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

Job: _____  Part No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	<b>DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Water Jet <input type="checkbox"/>            Supplier <input type="checkbox"/>            Quality <input type="checkbox"/> </div> </div>		
Date :	Sequence #:	QTY Affected :		MRB (QSI042)
Description Work Order Deviation		Disposition		Completed By
				Lead hand / Supervisor
				QC / QA Coordinator
<b>Root Cause</b>  <div style="display: flex;"> <div style="flex: 1;">           Operator <input type="checkbox"/>            Manufacturing Process <input type="checkbox"/>            Equip/Tooling <input type="checkbox"/>            Handling/Presservation <input type="checkbox"/>            Material <input type="checkbox"/>            Product Improvement <input type="checkbox"/>            Process Improvement <input type="checkbox"/>            Human Factors <input type="checkbox"/> </div> <div style="flex: 1;"> <input type="checkbox"/> Pressure/Forced  <input type="checkbox"/> Bending  <input type="checkbox"/> Crushing  <input type="checkbox"/> Cracks  <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist  <input type="checkbox"/> Marks/Chatter  <input type="checkbox"/> Mislabeled         </div> </div>		<b>FAULT CATEGORY</b>  <div style="display: flex;"> <div style="flex: 1;"> <input type="checkbox"/> Contamination  <input type="checkbox"/> Misaligned/off center  <input type="checkbox"/> BOM/Route  <input type="checkbox"/> Broken/Damage/Defect  <input type="checkbox"/> Incomplete/Unclear Instructions  <input type="checkbox"/> Drill Holes  <input type="checkbox"/> Fit/Function         </div> <div style="flex: 1;"> <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Folio/Program  <input type="checkbox"/> Grain Direction  <input type="checkbox"/> Weld  <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Out of Sequence  <input type="checkbox"/> Off-set/Set-up         </div> <div style="flex: 1;"> <input type="checkbox"/> Positioned Wrong  <input type="checkbox"/> Outside Tolerance  <input type="checkbox"/> Drawing  <input type="checkbox"/> Finish  <input type="checkbox"/> Part Lost/Missing  <input type="checkbox"/> Misread         </div> </div>		
Other/Details:				